

633.01

27

Date: Tuesday, 6/19/2007 2:04:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 32945A		
Estimate Number	: 10176		
P.O. Number	: N/A	Part Number	: D2563
This Issue	: 6/19/2007 S.O. No. : N/A	Drawing Number	: D2563 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 32389A	Material	: N/A
Written By	:	Due Date	: 7/6/2007
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est Rev:G 02.07.31 Re-format Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2244116	Step Extrusion
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: B28216

Q.M 07.08.14

10

2.0	D267334	End Plate
-----	---------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch
B32404

SE 07.08.27 10

3.0	D2561	Lug Plate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch
B32403

SE 07.08.27 10

4.0	D2564	Mounting Angle
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch
B32460 = 13
B30464 = 7

SE 07.08.27 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:04:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32945A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563 *Q.M. 07.08.14* 10

2-Deburr ends *SL 07.08.27* 10

3-Weld (1 End CAP, LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343
A/R AL ROD Batch: *M103794* *SL 07.08.28* 10

4-Grind *Q.M. 07.08.28* 10

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION *PD 07.08.28* (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *Q.M. 07.08.29* 10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *M 07.08.29* (10)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024 *SL 09.08.29* 10

2-Weld Remainig End as per Dwg D2563 using DT 8343
A/R AL ROD Batch: *M103794* *SL 07.08.29* 10

3-Grind *Q.M. 07.08.30* 10

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION *10/07/08/31* (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 5/10/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:04:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32945A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sn 07/08/31 (10)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068



FL

07/08/31 (10)

07-09-04 (10)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M 105386

M-1

07/09/04

(10x)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PPP B34346

07/09/11 (10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/10 (10)

Job Completion



07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

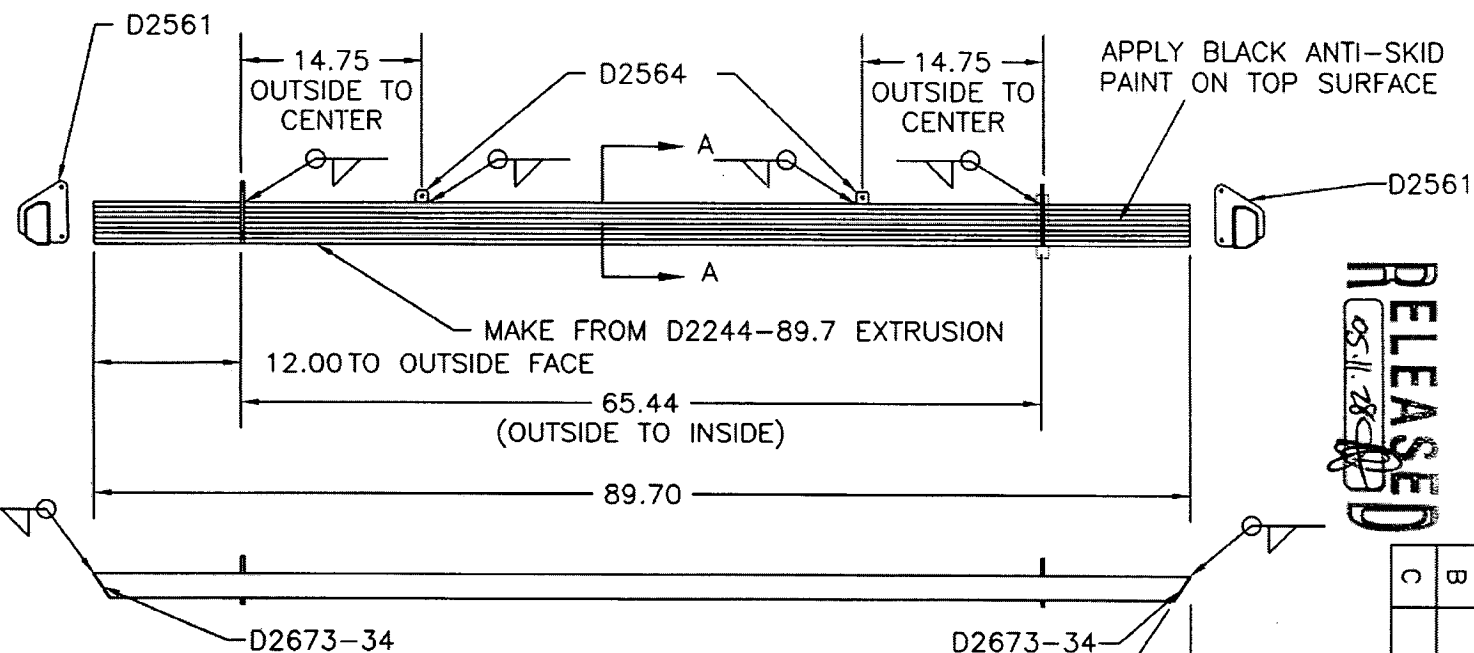
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05.11.28

DESIGN	BW	DRAWN BY	44	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2563	REV. C
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
		SCALE	1:15	
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
FOR AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 224454

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED